

Work Order ID 59620

Wednesday, June 09, 2010 8:40:44 AM



Page 1

Item ID: D3911-5

Revision ID:

Item Name: Basket Stud Plate

Start Date: 6/9/2010 Start Qty: 12.00

Required Date: 6/24/2010 Req'd Qty: 12.00

Reference:

Approvals:

Process Plan:



Date: 10-6-09

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3911	C

100



Waterjet

FLOW CNC Waterjet

304 .125

Memo

Cut as per dwg D3911

Prog Rev: C

Dwg Rev: C

Deburr as required

=> m-k w/06/21



B10-6-17

(IS)

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

B10-6-17

Barcode for Work Order ID 59620

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59620

Wednesday, June 09, 2010 8:40:44 AM



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Item ID: D3911-5

Accept



Setup Start



Revision ID:

Item Name: Basket Stud Plate

Stop



Start Date: 6/9/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/24/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

S106121

0.00



QC

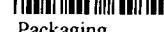
Memo

Quality Control

130

Identify as per dwg & Stock Location: 098

0.00



Packaging

Memo

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

0.00

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Picklist Print

Wednesday, June 09, 2010 8:40:48 AM

Page 1

Work Order ID: 59620



Parent Item: D3911-5



Parent Item Name: Basket Stud Plate

Start Date: 6/9/2010

Required Date: 6/24/2010

Comments: IPP RevA: new issue DD 09.11.17 verified by:EC
AS PER REV B 10-03-23 JLM VERIFIED BY:DD

IPP REV:B

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	150.7669	0.0299	0.377684	15	8/10/2010	17

304/316 0.125 Sheet

Location	Loc Qty	Loc Code
MAT	150.7669	
114488	22.7669	
114799	128	

114488

15

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	<i>59620</i>
Description: Basket Stud Plate	Part Number:	D3911-5
Inspection Dwg: D3911 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by: <u>BS</u>	Audited by: <u>S</u>	Preliminary Approval:
Date: <u>10-6-17</u>	Date: <u>10/06/21</u>	Date:

Rev	Date	Change	Revised by	Approved
A	10.04.20	New Issue	KJ	

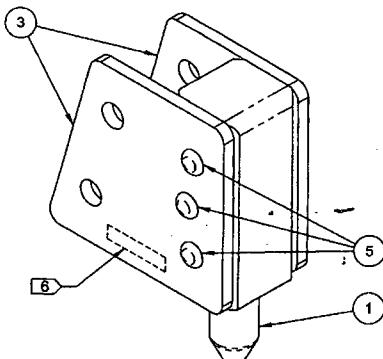
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D3911-041	BASKET INSTL STUD ASSY (LOWER)
		X	D3911-043	AFT EYEBOLT RECEIVER ASSY
1	1		D3911-1	BASKET INSTL STUD (LOWER)
2		1	D3911-3	AFT EYEBOLT RECEIVER
3	2		D3911-5	BASKET STUD PLATE
4		2	D3911-7	BASKET PLATE-EYEBOLT RECEIVER
5	3	4	MS20615-4M20	RIVET

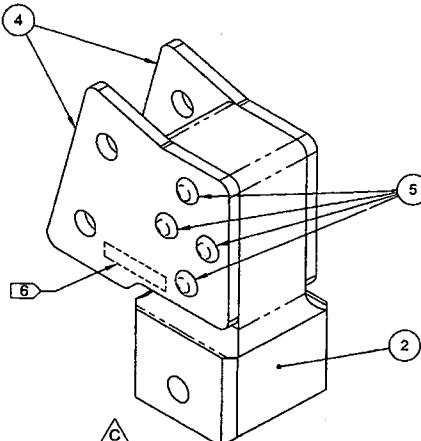


D3911-041 BASKET INSTL STUD ASSY (LOWER)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3911-04X USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 0.63 lbs
-043: 0.99 lbs

C



D3911-043 AFT EYEBOLT RECEIVER ASSY

RELEASED
2010-04-16
JPH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMNT
WITHOUT NOTICE
WORK ORDER
NO. 59620
B3911-043

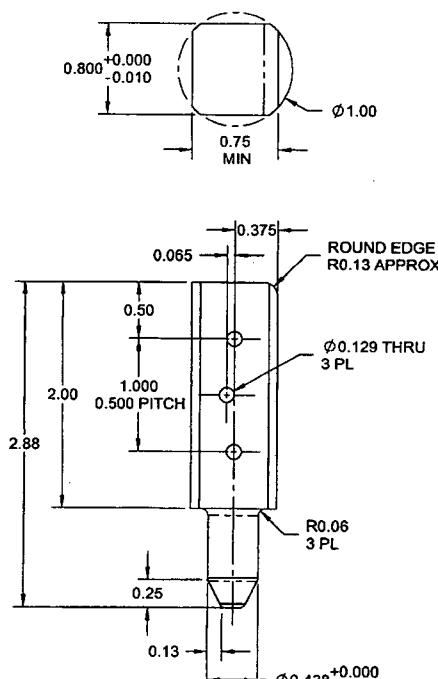
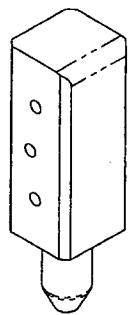
C	BOM: QTY (2): D4087-1 & MS21209-C610 REMOVED FROM D3911-043 & D3911-041. DETAIL UPDATES. SPEC. ADDED TO NOTES (SHT 2). DIM 0.375 WAS 0.400 (C3-3).	JPH	10.04.06
B	DIAMETER (B3-2) AND DIM ADDED (B2-2) & (C3-2)	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO. D3911	
MFG. APPR.	JPH	REV. C SHEET 1 OF 3	
APPROVED	JPH	TITLE AFT HARDPOINT, BASKET	
DE APPR.	JPH	SCALE NTS	
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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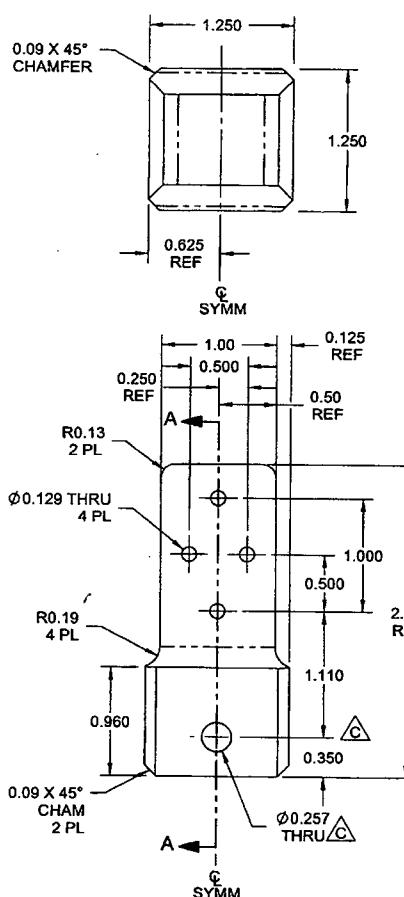
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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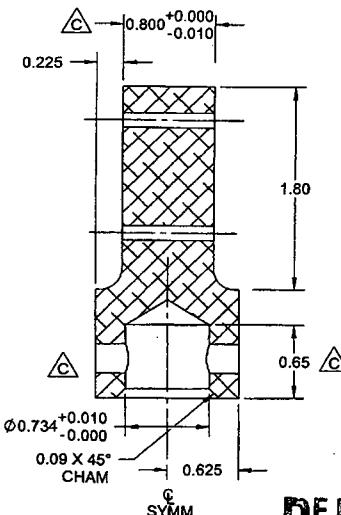
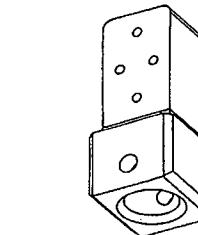
D3911-1 BASKET INSTL STUD (LOWER)



D3911-3 AFT EYEBOLT RECEIVER

NOTES:

- 1) MATERIAL -1: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
-3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT: -1: 0.36 lbs
-3: 0.73 lbs



SECTION A-A

wl059620

RELEASED
2010-04-14
M

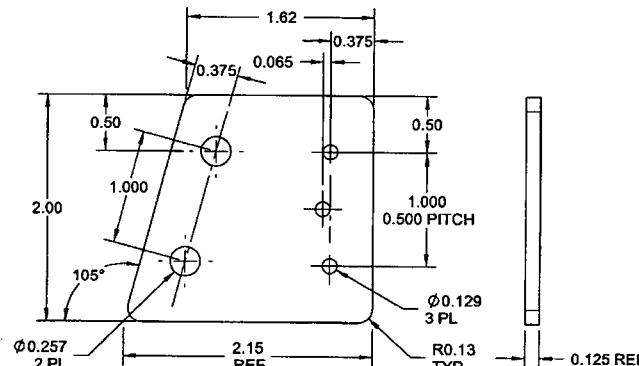
DESIGN	JPH	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. D3911
MFG. APPR.	<i>[Signature]</i>	REV. C SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE AFT HARDPOINT, BASKET
DE APPR.	<i>[Signature]</i>	SCALE NTS
DATE	10.04.06	© COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries



D3911-5 BASKET STUD PLATE

NOTES:

1) MATERIAL -5 & -7: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
PER DART SPEC M304S11GA OR M303S11GA

2) FINISH: NONE

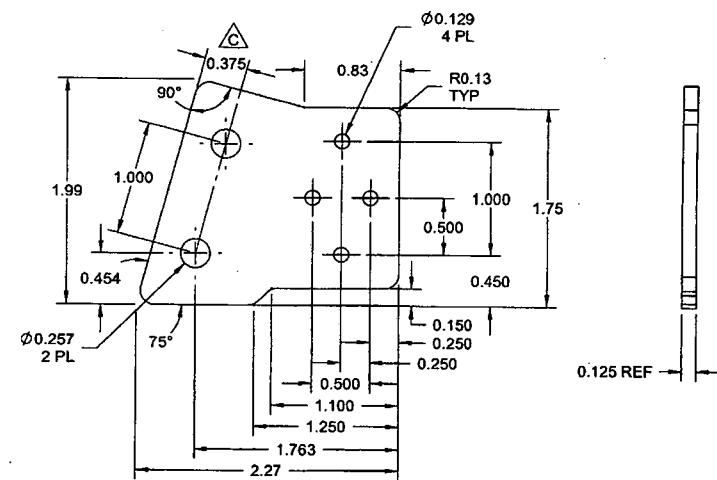
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BEND SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY AT ASSEMBLY

7) WEIGHT -5: 0.13 lbs
-7: 0.13 lbs



D3911-7 BASKET PLATE-EYEBOLT RECEIVER

RELEASED
2010-04-14
M

DESIGN	JPH	DART AEROSPACE LTD		
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>Jo</i>	DRAWING NO.	REV. C	
MFG. APPR.	<i>Jo</i>	D3911	SHEET 3 OF 3	
APPROVED	<i>Jo</i>	TITLE	SCALE	
DE APPR.	<i>Jo</i>	AFT HARDPOINT, BASKET		
DATE	10.04.06	NTS		

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